

642-412 BL

Blue

Dart Aerospace Ltd.

Date: Monday, 17/11/2008 10:35:55 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
 Job Number : 4237A
 Estimate Number : 10522
 P.O. Number :
 This Issue : 17/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SKIDTUBES
 Previous Run : 41733A
 Part Number : D206642441
 Drawing Number : D2650 REV E
 Project Number :
 Drawing Revision : E
 Material :
 Due Date *slip* : 10/01/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *JUD 08-11-17*
 Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
 Est Rev: I 08-05-01 add QC3 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A RJ

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2620 Bent Tube 3" OD *42 769*

JB 8-11-18

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2647 Fwd Cap *235475*

BE 8-11-18

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod *m/09813/m/09213**BE 8-11-18*

4-Grind weld flush to cap on top surface only.

BE 8-11-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 17/11/2008 10:35:55 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 43467A

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

JB 8-11-19

M 8-11-19

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

D M 8-11-19

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RE 8-11-19

7.0

D26547

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

43507

D M 8-11-19

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 12/11/08

Time: 3:30

Finish Date: 21/11/20

Time: 8:25 AM

M 8-11-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: \ _____ Date: _____

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 43467A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

Sikaflex expiry date:

M109499
8-11-30

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/20 (X)

10.0

D2649

Cross Bolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

24306 BF 08/11/20

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M109213 BE 08/11/20

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

5L8-11-23

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

JD 8-11-24

12.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

84599

JD 8-11-24

13.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

109431

JD 8-11-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 43467A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

106167

Job 8-11-24

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Job 8-11-24

16.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/11/24 (40)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/24 (40)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

+ Touch-up Alodine

91 08-11-26 (40)

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME GREY

B 10992

-SPRAY PAINT DELFLEET BLUE

B 105918

-CLEAR DELFLEET

B 109816

W 08-11-27 (1)

20.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

08-12-01 (2)

21.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

1342361

W 08-12-03 (40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 43467A

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
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22.0	D265615	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-15 Wearshoe B41125 *JH*

23.0	D265623	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-23 Wearshoe B41822 *JH*

24.0	D265637	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-37 Wearshoe B41634 *JH*

25.0	D34291	Wearpad
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3429-1 Wearpad B42779 *JH*

26.0	ALS41032130	Insert
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Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number Description Batch

60 ALS4-1032-130 Inserts M105819

or (see QSI 017)

JH 08-12-03 *(X)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 43467A

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	AN960JD10L	Washer
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Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number Description Batch

60 AN960JD10L Washer M105793 *ju*

28.0	MS27039108	Screw
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Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

Qty Part Number Description Batch

62 MS27039-1-08 Screw M109061 *ju*

29.0	D26511	Plug
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Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 D2651-1 BLUE Plugs B43382 *ju*

30.0	D26513	O-Ring
------	--------	--------



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 D2651-3 O-Rings 1341972 *ju*

31.0	AN960JD416	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer M108161 *ju* 08-12x03 *(XD)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D206642441

Job Number:



Seq. #: Machine Or Operation: Description :

32.0 MS27039406 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw M109061 JH

33.0 D2646 Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 BLUE Aft Cap B43792 JH

34.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 M109942

Sikaflex expiry date: 08111

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291 M109942

Sikaflex expiry date: 08111

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M109219

JH 08.12.04 (40)

35.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JH 08.12.04 (40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 43467A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PPP 43466*

Pc 8/12/9

37.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUM
X.				D2650-1
	X			D2650-3
		X		D2650-5
			X	D2650-7
1	1	1	1	D2600-1-160
1				D2654-1
	1			D2654-3
		1		D2654-5
			1	D2654-7
1	1	1	1	D2646
1	1	1	1	D2647
17	18	19	23	D2649
16	18	14	22	D2651-1
16	18	14	22	D2651-3
1	1	1	1	D2680-041
2	2			D3286-1
2	2			D3286-3
42	44	54	60	ALS7-1032-130
2	2	2	2	AN960JD10L
2	2	2	2	CCR264SS3-3
2	2	2	2	CR3212-4-03
2	2	2	2	MS27039-1-08
1	1	1	1	MS27039-4-06
1	1	1	1	AN960JD416
52	52			CR3212-4-04



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER
-POWDER COAT WHITE (4.3.5.1) PER
-BLACK ANTI-SKID PAINT AS INDICATE
DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OT
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN
GROUND. IT IS ACCEPTABLE TO POLISH OUT
MAXIMUM REDUCTION IN DIAMETER OF 0.150
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLE
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS U
TUBE, AND DT8056-7 ON -7 TUBE. INSTALL IN
- 13) TOLERANCES ARE PER DART QSI 018 UNLES

ED TO CURRENT STANDARDS. SHT CTION AND DETAIL VIEWS	AJS	08.08.08
SHT 6. SHT 1 IN PL PART D2649 QTY SECT C-C GRIND INSTRUCTIONS NOTE 7 (SEE NCR 239).		
CHG DRILL, ADD CHAMFER	CP	06.03.30
P. DE09136/9153/9163	CP	04.05.17
ANDLING ON D2650-1/-3		
PATTERN AND FRONT END	DS	97.10.29
RED CHANGES	DS	97.06.26
	DS	97.03.25
DESCRIPTION	BY	DATE

DART AEROSPACE USA, INC

PORT HADLOCK, WA

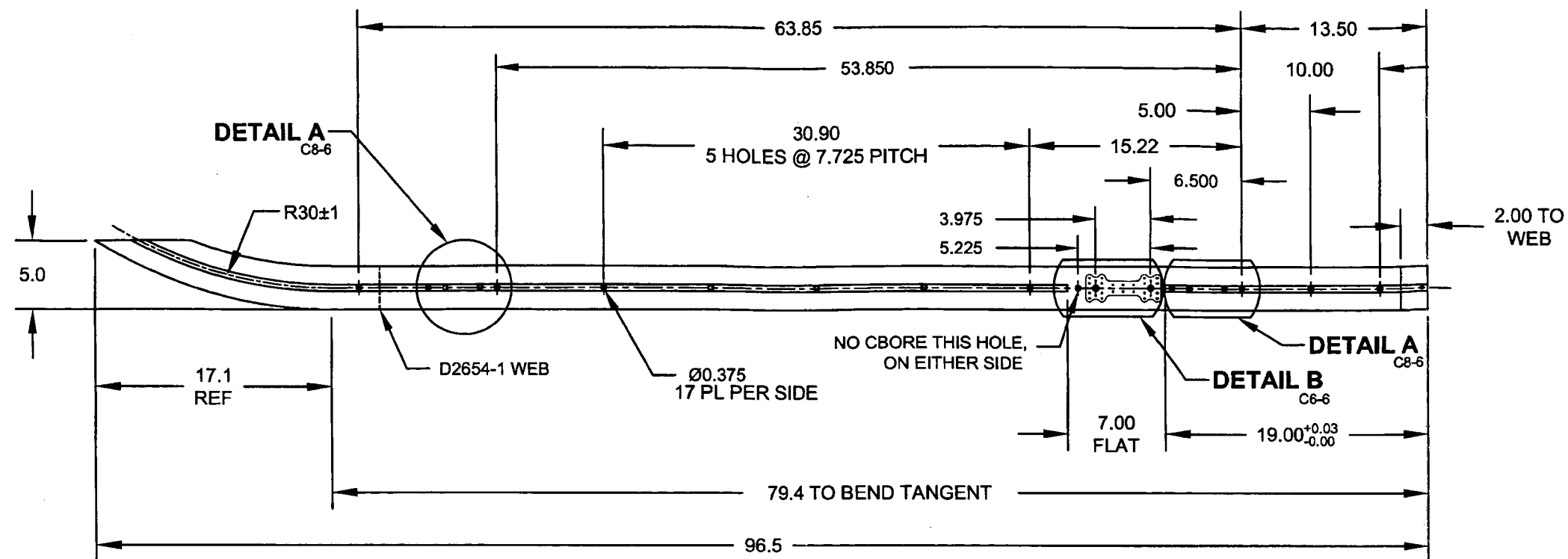
DRAWING NO. REV. F
D2650 SHEET 1 OF 6

TITLE SCALE
206/407 SKIDTUBE ASSEMBLIES NTS

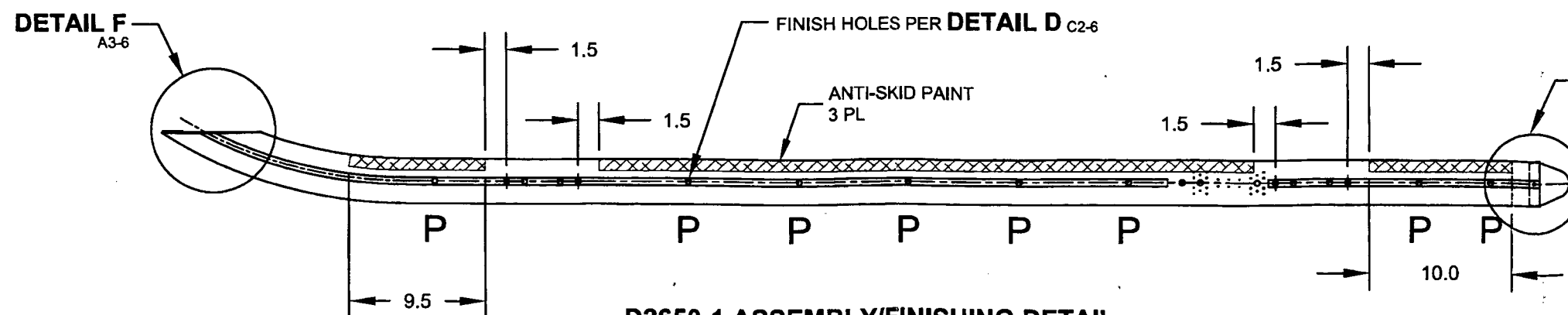
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08-07-23 MP



D2650-1 BENDING/DRILLING DETAIL

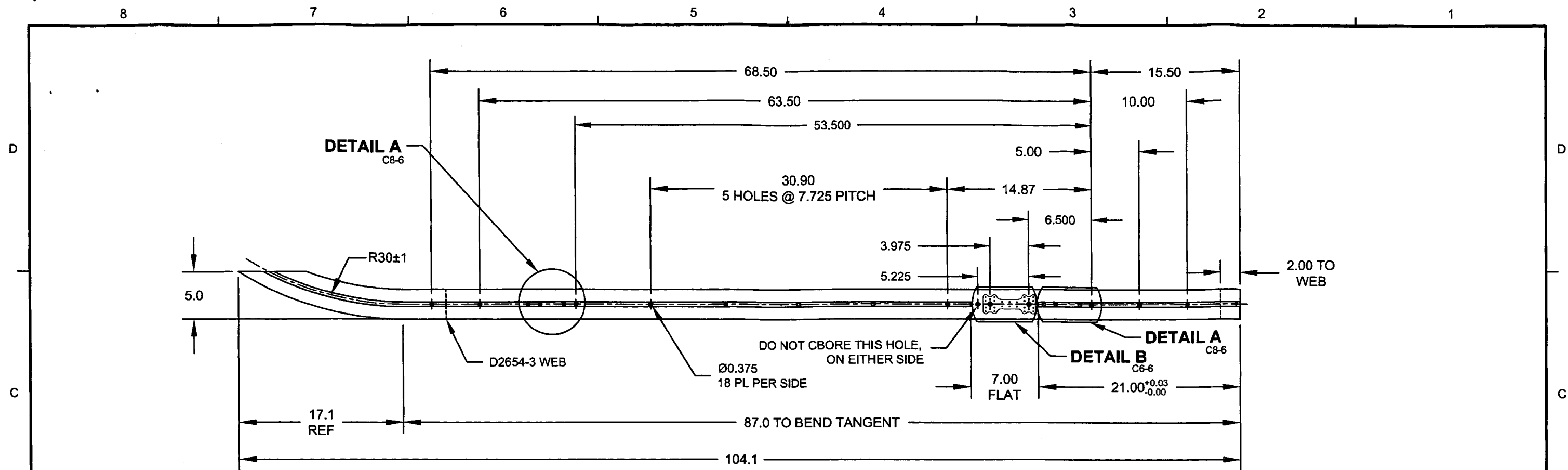


D2650-1 ASSEMBLY/FINISHING DETAIL

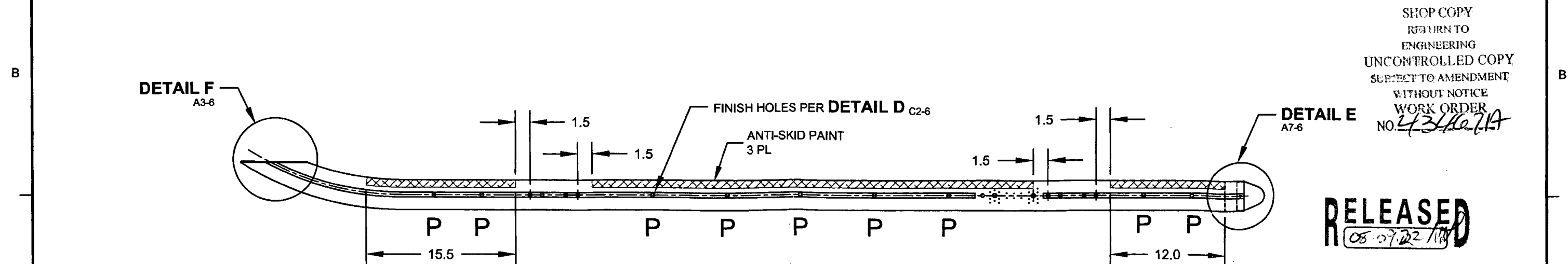
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NO. 43467A

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680922/117

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D2650-3 BENDING/DRILLING DETAIL

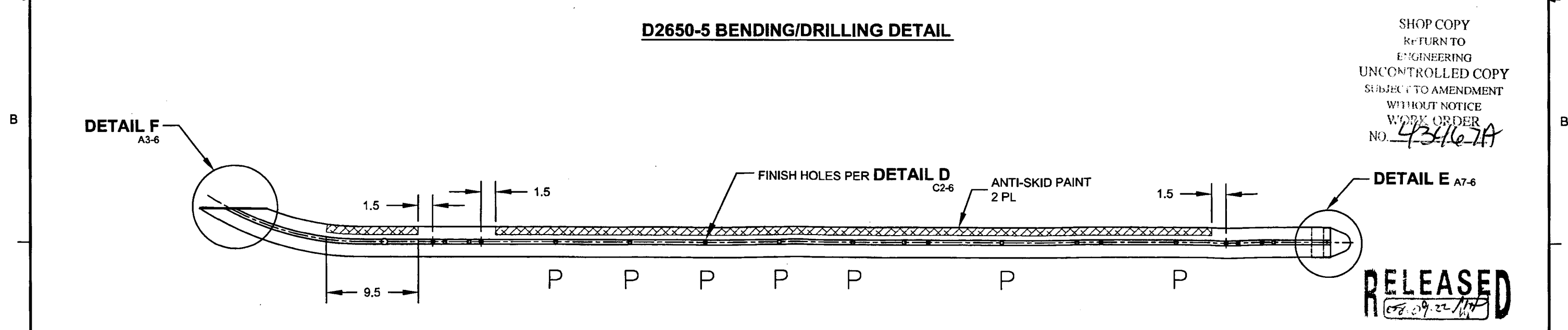
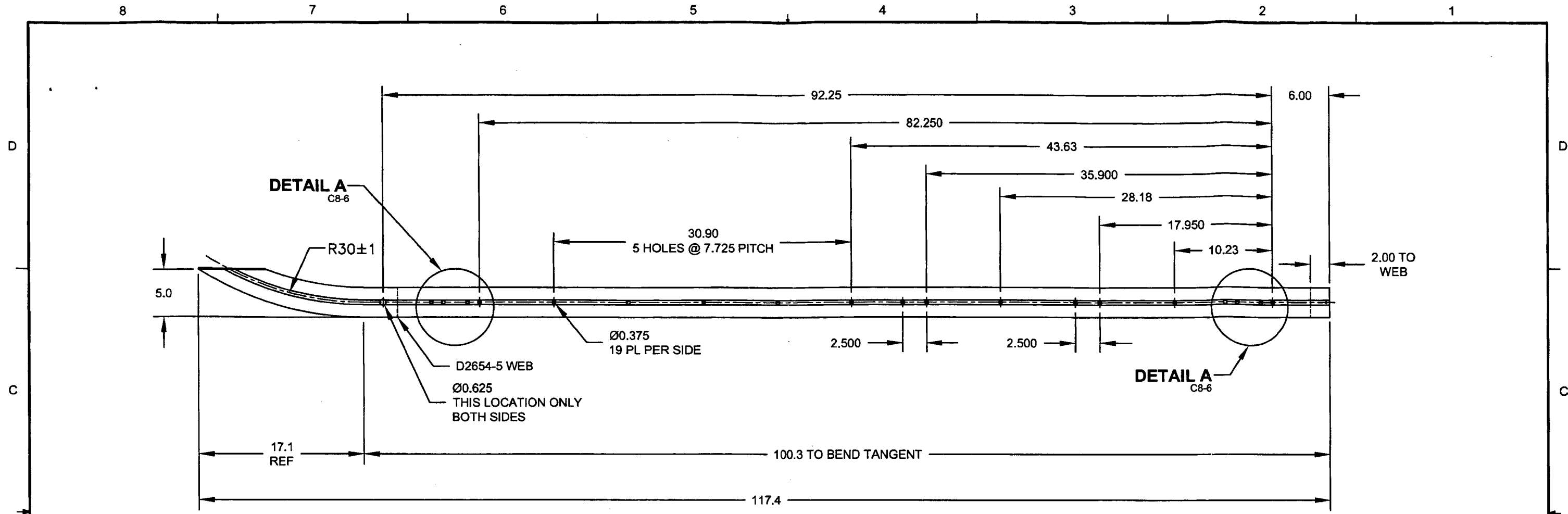


D2650-3 ASSEMBLY/FINISHING DETAIL

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NO. 43607A

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08-07-22-100

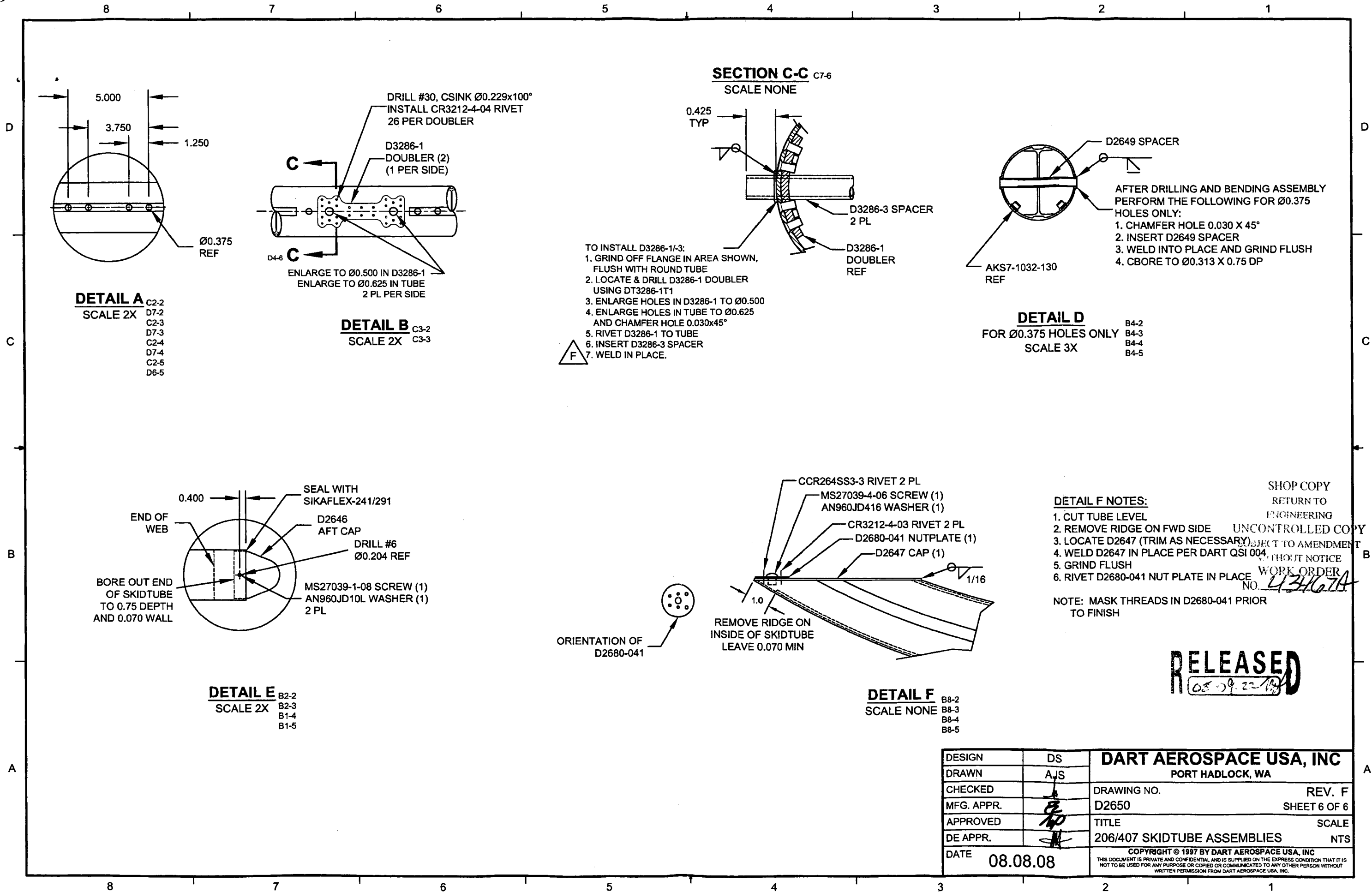
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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08.09.22/1/17

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	E	D2650	SHEET 4 OF 6
APPROVED	10	TITLE	SCALE
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NO. 180

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B42582 A
Part number: A206-642-441
Description: 206 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Drael Date of Test Coupon 08/10/30
Welder Barclay Elliot Date of Test Coupon 08/10/30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld